

86731

July-06-12 11:46:49 AM

N900040100

Setup Start ***NS1***

Stop *NS2*

Customer:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Page 2

Quality Control

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Page 3

S 12/08/16

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Work Order ID 86731***86731***

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July-06-12 11:46:49 AM

Item ID: D3136-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Window Assembly
Start Date: 7/06/12 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 8/10/12 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

MLJ 12/08/17

11208-16

Dart Aerospace Ltd

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Picklist Print

July-06-12 11:46:48 AM

Page 1

Work Order ID: 86731

Parent Item: D3136-043

Start Date: 7/06/12

Required Date: 8/10/12

Parent Item Name: Window Assembly

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:A04.02.04New issueKJ/DS

IPP Rev.B 07.05.29 Thermoform in-house DL

IPP rev C 07.09.28 Rev E dwg EC verified by:DD IPP Rev:D 10.06.24 added note in qc5

seq 170 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3108-9		Manufactured	No			100	Each	580.0000	2	16			
Decal													

Location

Loc Qty

Loc Code

ST026	580	
34554	80	
46546	500	

16.

12/08/10.

MACRLICS.125		Purchased	No			170	sf	278.1990	3.9	31.2			
1/8" Polycast II Sheet										32			

Jim 12-8-10

Location

Loc Qty

Loc Code

MAT019	278.199	
110633	3	
117324	0.2467	
117431	10.7967	
119591	39.16	
121850	224.9956	

119591 x6 = 245. F.
121850 x2 = 8 S.F.

Dart Aerospace Ltd

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DART AEROSPACE LTD		Work Order:	86731
Description: Window Assembly		Part Number:	D3136-043
Inspection Dwg: D3136 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.00	+/-0.030	21.00"	✓		T	HBO1
25.75	+/-0.030	25.75"	✓		T	
26.25	+/-0.030	26.25"	✓		T	

Measured by: JM	Audited by: [Signature]	Prototype Approval:	N/A
Date: 12-8-10	Date: 12/08/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	[Signature]

Dart Aerospace Ltd

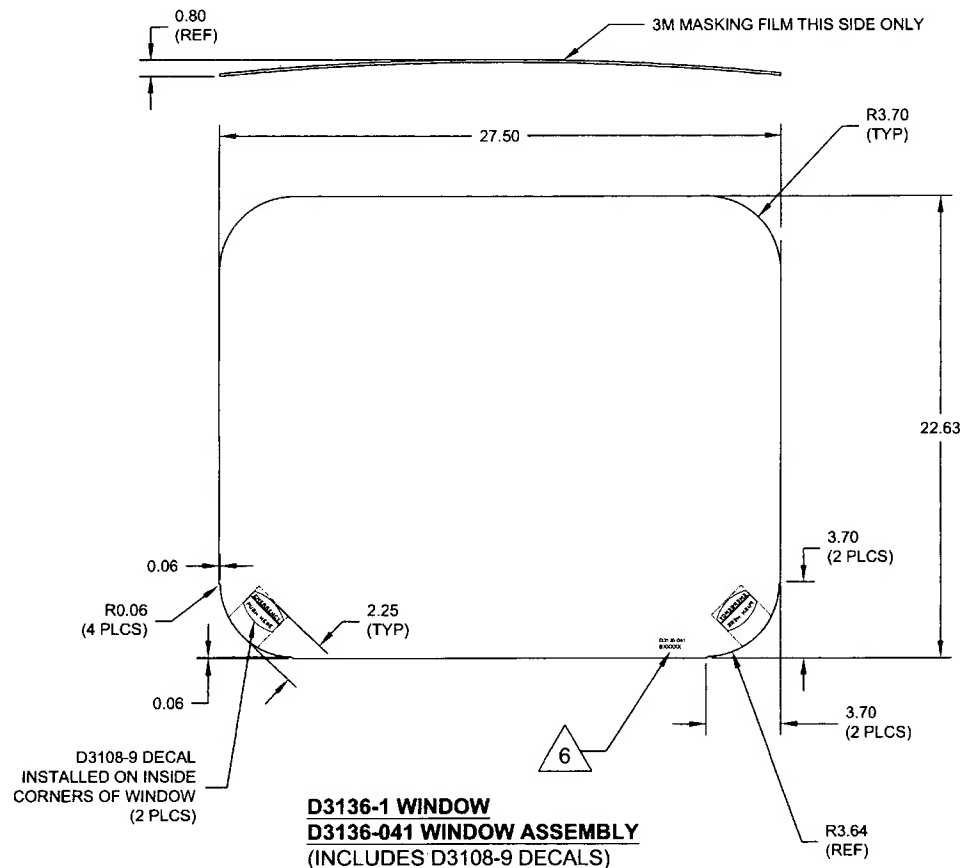
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NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3136-041" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 2.98 +/- 0.66 LBS
- 8) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
b) DRAPE OVER D3136-T1 MOLD & CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

MOLD PER
DART TOOL
DT3136-T1

0.125
(REF)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86739

R140
(REF)

0.58
(REF)

RELEASED
07.09.22

E	REMOVE TRIM NOTE	DC	07.09.10
D	UPDATED MATERIAL NOTES	RF	05.12.01
C	ADDED FORMING & ENGRAVING SPEC	KJ	04.05.05
B	ADDED D3136-3 AND D3136-043	RF	04.01.21
A	NEW ISSUE	DS	02.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.09.10		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3136	REV. E SHEET 1 OF 2
TITLE WINDOW ASSEMBLY	SCALE 1:6

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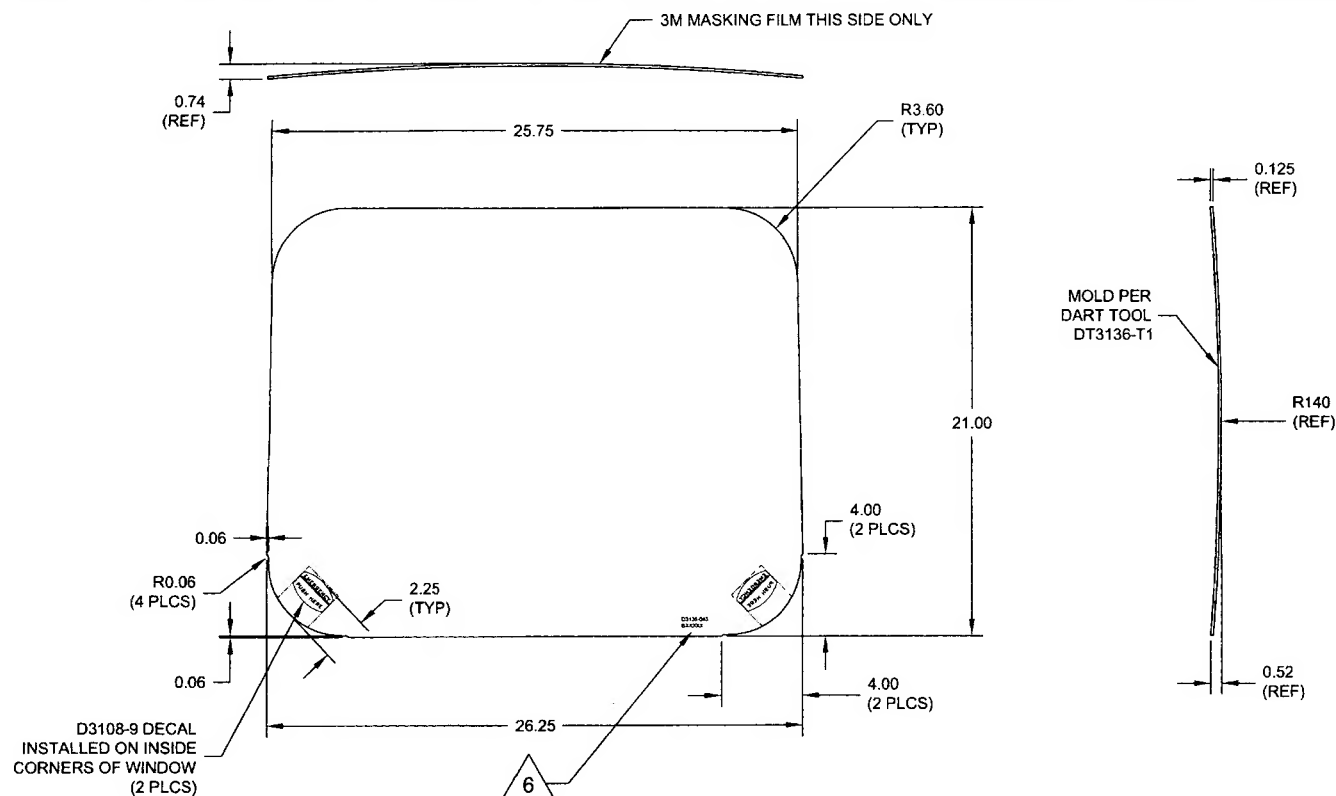
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D3136-3 WINDOW
D3136-043 WINDOW ASSEMBLY
 (INCLUDES D3108-9 DECALS)

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c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3136	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WINDOW ASSEMBLY	1:6
DATE	07.09.10	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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RELEASED
 07.09.22

86731

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